











Work Order ID 63498

Wednesday, November 03, 2010 10:28:39 A

Page 1

Item ID:	D2873-045	Accept		Setup	Start	
Revision ID:						
Item Name:	Nut Plate Assembly				Stop	
Start Date:	11/3/2010	Start Qty:	20.00		Cust Item ID:	
Required Date:	11/17/2010	Req'd Qty:	20.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>74</u>	Date:	<u>10-11-02</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2873	Rev A								
100		0.00							
	BAND SAW								
Bandsaw	Memo	0.00							
Jcaspa Bandsaw	Cut blanks: 1.000" x 0.375" x 2.700" long								
110.		0.00							
	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Machine as per Folio FA and Dwg D2873 Identify as D2873-5								
	Dwg Rev <u>A</u> F1819Folio Rev <u>AA</u>								
120		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

and 10/11/03

and 10/11/04

and 10/11/04

20 ~~0~~

20 ~~0~~

20 ~~0~~

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63498

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Item ID: D2873-045

Accept

Revision ID:

Item Name: Nut Plate Assembly

Start Date: 11/3/2010 Start Qty: 20.00

Required Date: 11/17/2010 Req'd Qty: 20.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00

JL 10/11/08



QC

Memo

0.00

Quality Control

140

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-Deburr □2- C'sink as per Dwg D2873

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S. 10/11/11

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

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Wednesday, November 03, 2010 10:28:39 A

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Start Date: 11/3/2010 Start Qty: 20.00

Cust Item ID:

Required Date: 11/17/2010 Req'd Qty: 20.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Chemical Conversion Coat per QSI005 4.1

0.00

⇒ JH

10/11/11

20

Ø



HandFinish

Memo

0.00

Hand Finishing

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

20 BL 10-11-11.

Quality Control

180

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-Assemble as per Dwg D2873 □2-Identify as D2873-045

CP 10/11/15 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

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Revision ID:

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Item Name: Nut Plate Assembly

Start Date: 11/3/2010 Start Qty: 20.00

Cust Item ID:

Required Date: 11/17/2010 Req'd Qty: 20.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

SB 10/11/15

(20)

200

Identify as per dwg & Stock Location: Matt

0.00



Packaging

Memo

0.00

Packaging

10/11/15 (20)

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/11/15

MF
10-11-15

W/O:		WORK ORDER CHANGES					
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, November 03, 2010 10:28:57 AM

Page 1

Work Order ID: 63498

Parent Item: D2873-045

Parent Item Name: Nut Plate Assembly




Start Date: 11/3/2010

Required Date: 11/17/2010

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP A 05.09.13 New issue KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21075L5  Nut Plate		Purchased	No			100	Each	35.0000	2	40			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST350		35							
				115908		35							
M6061T6B0.375X01.00 0  6061T6 BAR .375 x 1.00		Purchased	No			180	f	27.6952	0.225	4.736842			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT01		0.45							
				113325		0.45							
				MAT04		27.2452							
				114352		27.2452							
MS20426AD4-6  Rivet		Purchased	No			180	Each	2,602.000	4	80			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST317		2602							
				110139		2602							

PS 10/11/15
M116082 (4x)

4.736 or 10/11/03

PS 10/11/15
80

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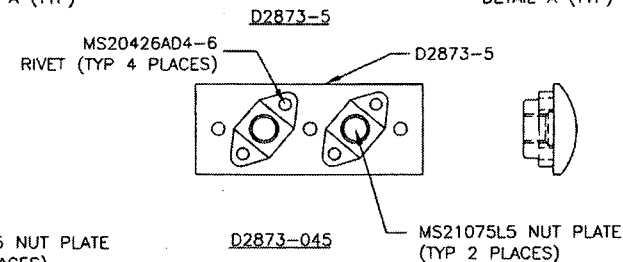
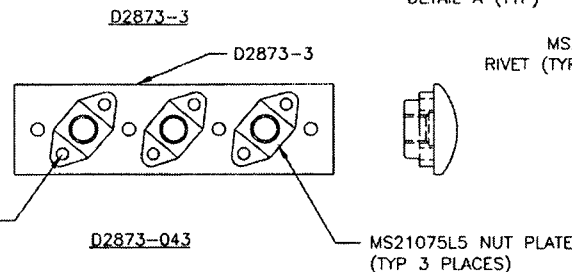
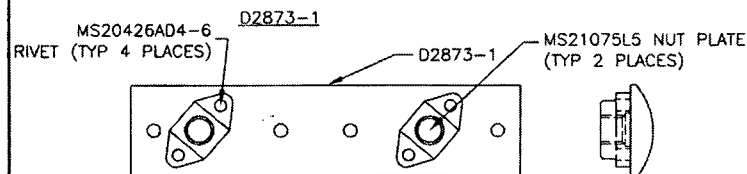
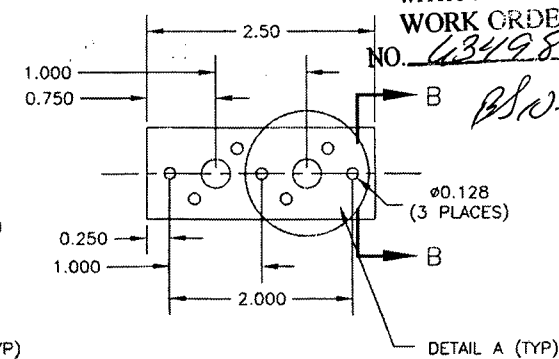
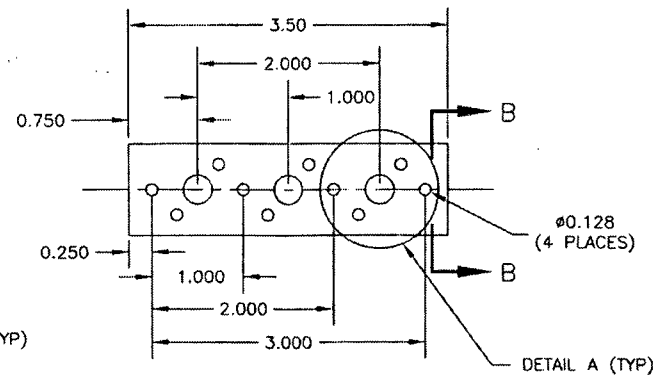
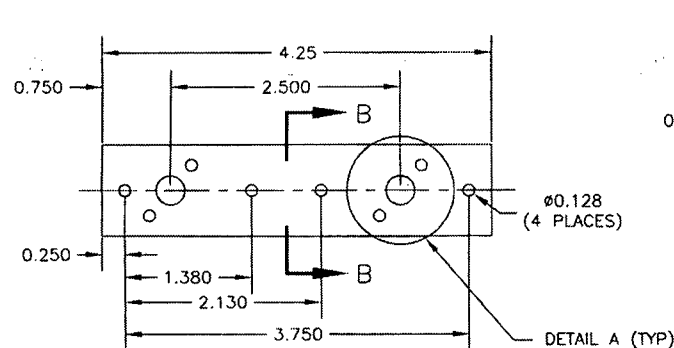
NOTE: Date & initial all entries

SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 63498

BSN-18-07



D2873-041

MS20426AD4-6
RIVET (TYP 6 PLACES)

D2873-043

MS21075L5 NUT PLATE
(TYP 3 PLACES)

D2873-045

MS21075L5 NUT PLATE
(TYP 2 PLACES)

D2873-1/-3/-5 RADIUS BLOCK

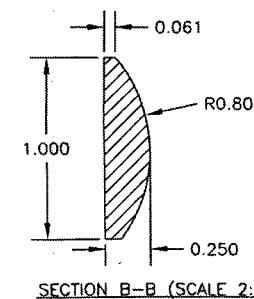
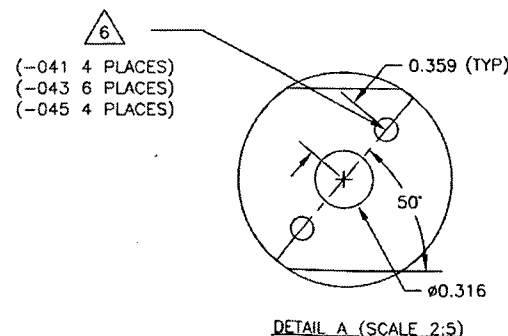
- 1) MATERIAL: 5052-H32/H34 BAR (QQ-A-225/7) (REF. DART SPEC M5052H32B1.000X0.250) OR 6061-T6 BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC M6061T6B1.000X0.250)
- 2) FINISH: ACID ETCH AND ALODINE PER DART OSI 005 4.1
- 3) TOLERANCES ARE PER DART OSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) Ø0.128 PILOT + C'BORE CURVED SIDE Ø0.230X0.125 DEEP + C'SINK CURVED SIDE Ø0.225 x 100"

D2873-041/-043/-045 NUT PLATE ASSEMBLY

- 1) INSTALL MS21075L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-6 RIVETS

D2873-041/-043/-045 NUT PLATE ASSEMBLY PARTS LIST

-041	-043	-045	PART NUMBER	DESCRIPTION
X			D2873-041	NUT PLATE ASSEMBLY
	X		D2873-043	NUT PLATE ASSEMBLY
		X	D2873-045	NUT PLATE ASSEMBLY
1			D2873-1	RADIUS BLOCK
	1		D2873-3	RADIUS BLOCK
		1	D2873-5	RADIUS BLOCK
4	6	4	MS20426AD4-6	RIVET
2	3	2	MS21075L5	NUT PLATE



RELEASED
05.07.26

A	05.07.26	NEW ISSUE
DESIGN PH	DRAWN BY PH	DART DART AEROSPACE LTD WILKESBORO, ONTARIO, CANADA
CHECKED PH	APPROVED PH	DRAWING NO. D2873
DATE 05.07.26	TITLE RADIUS BLOCK	REV. A SHEET 1 OF 1 SCALE 4:5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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